

What is claimed is:

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1. A resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material,

wherein a position of a burr to be generated by a flow of said resin material into a gap between a combined molding die and a core in a process of molding of said resin piston for a master cylinder by injection molding is a position ^{but} an inner wall surface of said communicating hole.

2. The resin piston for a master cylinder as in claim 1, wherein a groove making said inner wall surface nearby a part, with which said communicating hole communicates, of said through-hole flat in a direction in which said stopper pin is inserted.

3. The resin piston for a master cylinder as in claim 2, wherein a width of said groove is narrower than that of said through-hole and wider than a diameter of said stopper pin.

4. The resin piston for a master cylinder as in claim 1, wherein said through-hole includes a projecting part for preventing said stopper pin from being touched to the inner wall surface nearby a part with which said communicating hole communicates.

5. A resin piston for a master cylinder including a through-hole through which a stopper pin being a component

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of a valve mechanism of said master cylinder is inserted, a
concavity in which said valve mechanism is fixed by being
inserted therein, and a communicating hole communicating
with said through-hole from said concavity, said resin piston
5 for a master cylinder being molded by injection of a resin
material,

wherein:

said through-hole is molded with a core for
through-hole molding;

10 said concavity and said communicating hole are
molded with a core for molding a concavity;

a part where said through-hole communicates with
said communicating hole is molded in a state such that an
end of said core for molding a concavity is impacted in an
15 impact hole formed on said core for through-hole molding.

6. The resin piston for a master cylinder as in claim 5,
wherein:

said resin piston for a master cylinder is molded with a
die formed by a combination of a first die and a second die,
20 the first die including a first core, the second die including a
second core; and

said core for through-hole molding is constructed by a
combination of the first core and the second core, whereby
said impact hole is formed.

25 7. The resin piston for a master cylinder as in claim 5,
wherein a groove making said inner wall surface nearby a
part, with which said communicating hole communicates, of
said through-hole flat in a direction in which said stopper
pin is inserted.

8. The resin piston for a master cylinder as in claim 7, wherein a width of said groove is narrower than that of said through-hole and wider than a diameter of said stopper pin.

9. The resin piston for a master cylinder as in claim 5, wherein said through-hole includes a projecting part for preventing said stopper pin from being touched to the inner wall surface nearby a part with which said communicating hole communicates.

10. A resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material,

wherein:

said through-hole is molded with a core for through-hole molding;

said concavity and said communicating hole are molded with a core for molding a concavity;

an inner wall surface of said through-hole nearby a part where said communicating hole communicates with said through-hole is in a shape of a flat surface.

11. A master cylinder equipped with a resin piston for said master cylinder, said resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed

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by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, wherein a position of a burr to
5 be generated by a flow of said resin material into a gap between a combined molding die and a core in a process of molding of said resin piston for a master cylinder by injection molding is a position but an inner wall surface of said communicating hole.

10 12. A master cylinder equipped with a resin piston for said master cylinder, said resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed
15 by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, wherein: said through-hole is molded with a core for through-hole molding; said concavity and said communicating hole are molded with a core for
20 molding a concavity; a part where said through-hole communicates with said communicating hole is molded in a state such that an end of said core for molding a concavity is impacted in an impact hole formed on said core for
25 through-hole molding.

13. A master cylinder equipped with a resin piston for said master cylinder, said resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in

which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, wherein: said through-hole is molded with a core for through-hole molding; said concavity and said communicating hole are molded with a core for molding a concavity; an inner wall surface of said through-hole nearby a part where said communicating hole communicates with said through-hole is in a shape of a flat surface.

10 14. A die for molding a resin piston for a master cylinder, said die molding a resin piston for a master cylinder, said resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve
15 mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, said die comprising a core for through-hole molding for molding said through-hole and a core for molding a concavity
20 for molding said concavity and said communicating hole, wherein a part where said through-hole communicates with said communicating hole is constructed such that the part is molded in a state in which an end of said core for molding a concavity is impacted in an impact hole formed on said core
25 for through-hole molding.

15. A manufacturing method of a resin piston for a master cylinder for manufacturing a resin piston for a master cylinder including a through-hole through which a stopper pin being a component of a valve mechanism of said master

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5 cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material, said manufacturing method comprising the steps of:

molding said through-hole with a core for through-hole molding;

10 molding said concavity and said communicating hole with a core for molding a concavity; and

molding a part where said through-hole communicates with said communicating hole in a state such that an end of said core for molding a concavity is impacted in an impact hole formed on said core for through-hole molding.